
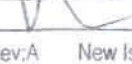


Date: Tuesday, 01/05/2007 2:18:10 PM  
 User: Linda Lacelle

## Process Sheet

Split  
 SB 07/05/14

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 31866-27  
 Estimate Number : 12679  
 P.O. Number : N/A  
 This Issue : 01/05/2007 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : N/A Type : SMALL /MED FAB  
 Previous Run : 31866  
 Written By :   
 Checked & Approved By :   
 Comment : Est Rev:A New Issue 07-01-30 JLM

Drawing Name : BRACKET

Part Number : D35701  
 Drawing Number : D3570 REV B  
 Project Number : N/A  
 Drawing Revision : B  
 Material : N/A  
 Due Date : 13/05/2007

Qty: 60 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S125 6061-T6 .125 Sheet



Comment: Qty.: 0.0746 sf(s)/Unit Total: 4.4730 sf(s)

6061-T6 .125 Sheet

Batch: M103156

\*\*\*Grain must be Along 4.63\*\*\*\*\*

SAD

07/05/04

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3570

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

SAD

07/05/04

JMF

07-05-07

60  
 60

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD

07/05/04

60

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SB 07-05-04

60

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1





Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Form as per Dwg D3570

SB 07/05/14

20

Dart Aerospace Ltd

| W/O:     |      | WORK ORDER CHANGES |    |          |     |   |   |
|----------|------|--------------------|----|----------|-----|---|---|
| DATE     | STEP | PROCEDURE CHANGE   | By | Date     | Qty | Approval<br>Chief Eng /<br>Prod Mgr   | Approval<br>QC Inspector  |
| 07/05/14 | 5    | u/o splice         | SS | 07/05/14 | 20  | <br>07/05/15 | <br>07/05/15 |
|          |      |                    |    |          |     |   |   |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 31866

Part Number: D35701

Job Number:



Seq. #:

Machine Or Operation:

Description :

1A- Fini

2-Cut excess materials per Dwg D3570.

3-Drill as per Dwg D3570

FF 07-05-11

6.0

QC5

INSPECT WORK TO CURRENT STEP



2005-15 (20)



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AD 07-05-15 (20)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 101601 H 07-05-15 (20)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 07/05/15 (20)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: GA

SB 07/05/15 (20)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

20 07/05/16

Job Completion



W. P. S. 16

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

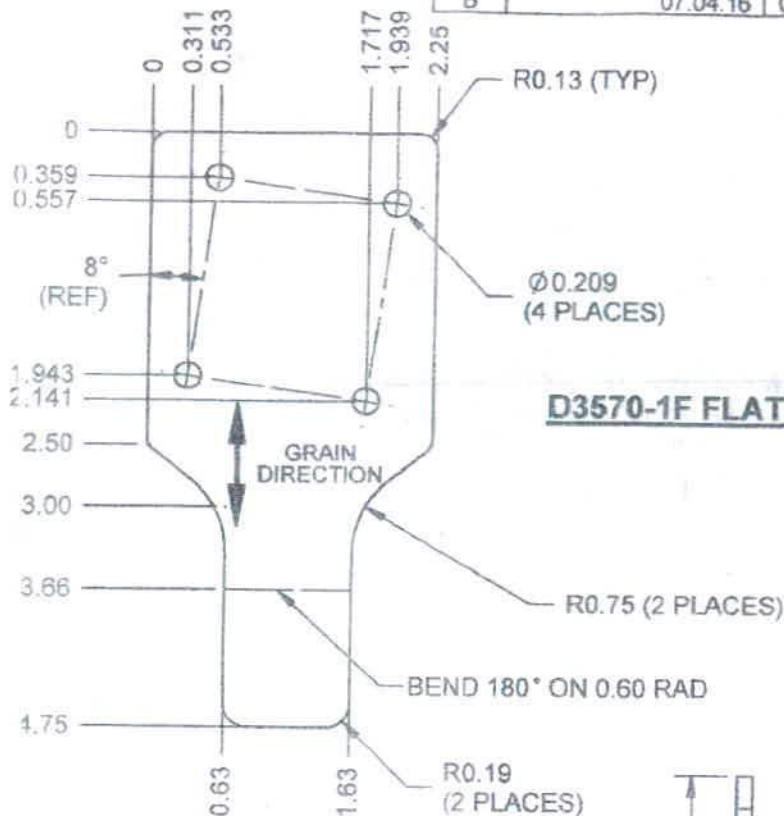
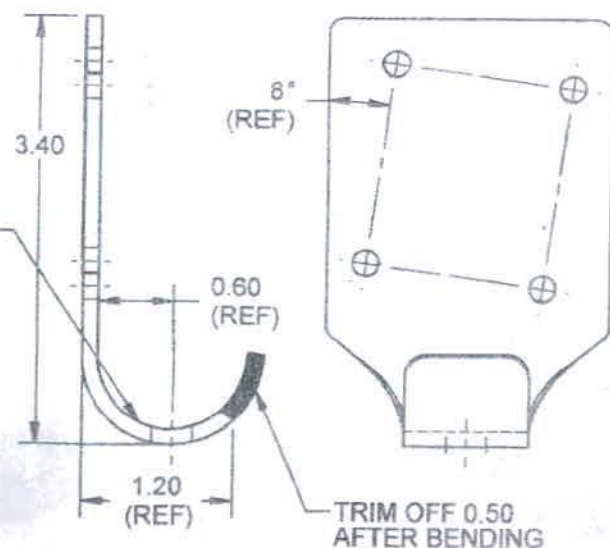
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**DART**

| DESIGN<br><i>LE</i>     | DRAWN BY<br><i>LE</i>                   | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
|-------------------------|---|--|------------------------|
| CHECKED<br><i>B</i>     | APPROVED<br><i>H</i>                    | DRAWING NO.<br><b>D3570</b>                              | REV. B<br>SHEET 1 OF 1 |
| DATE<br><b>07.04.16</b> | TITLE<br><b>BRACKET</b><br>SCALE<br>2:3 |  |                        |
| REV                     | DATE                                    | DESCRIPTION  |                        |
| A                       | 07.02.07                                | NEW ISSUE  |                        |
| B                       | 07.04.16                                | CHANGE BEND RAD TO 0.60 FROM 0.50                        |                        |

**RELEASED**07.04.25 *H***D3570-1F FLAT PATTERN**DRILL Ø0.328 AFTER BENDING  
CENTERED ON PART & ON BEND**D3570-1 BRACKET SHOWN**  
**(MAKE FROM D3570-1F)****D3570-2 BRACKET OPPOSITE**  
**(MAKE FROM D3570-1F)****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM 0.125" THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3570-1/-2" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR:   |      | WORK ORDER NON-CONFORMANCE (NCR)  |                             |                                   |                |                           |                       |                          |
|--------|------|---|-----------------------------|-----------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE   | STEP | Description of NC<br>Section A  | Corrective Action Section B |                                   |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|        |      |   | Initial<br>Chief Eng        | Action Description<br>Chief Eng   | Sign &<br>Date |                           |                       |                          |
| 070514 | 5.0  | Parts/ hole dimension of .600" was below by .040" → .080". Parts not made AS per drawing. | 2<br>QS/042                 | Re-work parts to Dwg. See NCR 163 | SS<br>07/05/15 | 2<br>07.05.15             | 2<br>QS/042           | 2<br>07.05.14            |
|        |      |   |                             |                                   |                |                           |                       |                          |
|        |      |   |                             |                                   |                |                           |                       |                          |

NOTE: Date & initial all entries

